

49

DART AEROSPACE LTD	Work Order:	21786
Description: Pedal Arm	Part Number:	D3206-1
Dwg: D3206 Rev. A	Qty:	4
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	04.10.25	4
2	PG	Issue P/O: <u>7007023</u> Email or Ship DXF file to vendor Laser Cut D3206-1 as per Dwg D3206 Material release note is required	LL	04.10.25	4
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	CL	05/01/05	4
4	QC6	Inspect dimensions as per Dwg D3206	2	05.01.18	4
5	GA	Deburr if necessary	2	05.01.18	4
6	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) per QSI 005 4.3	WM	05.01.19	4
7	QC3	Inspect Powder Coat	2	05.01.19	4
8	ST	Identify and Stock	2	05.01.19	4
9	AC	Cost / part <u>89.86</u>	SAC	05.01.21	4
10	DC	Close W/O <u>89.86</u> Inspect Level 21	JA	05.01.24	4

Rev	Date	Change	Revised By	Approved
A	04.04.15	New issue	KJ/RF	<i>[Signature]</i>

RELEASED
[Signature] 04.05.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

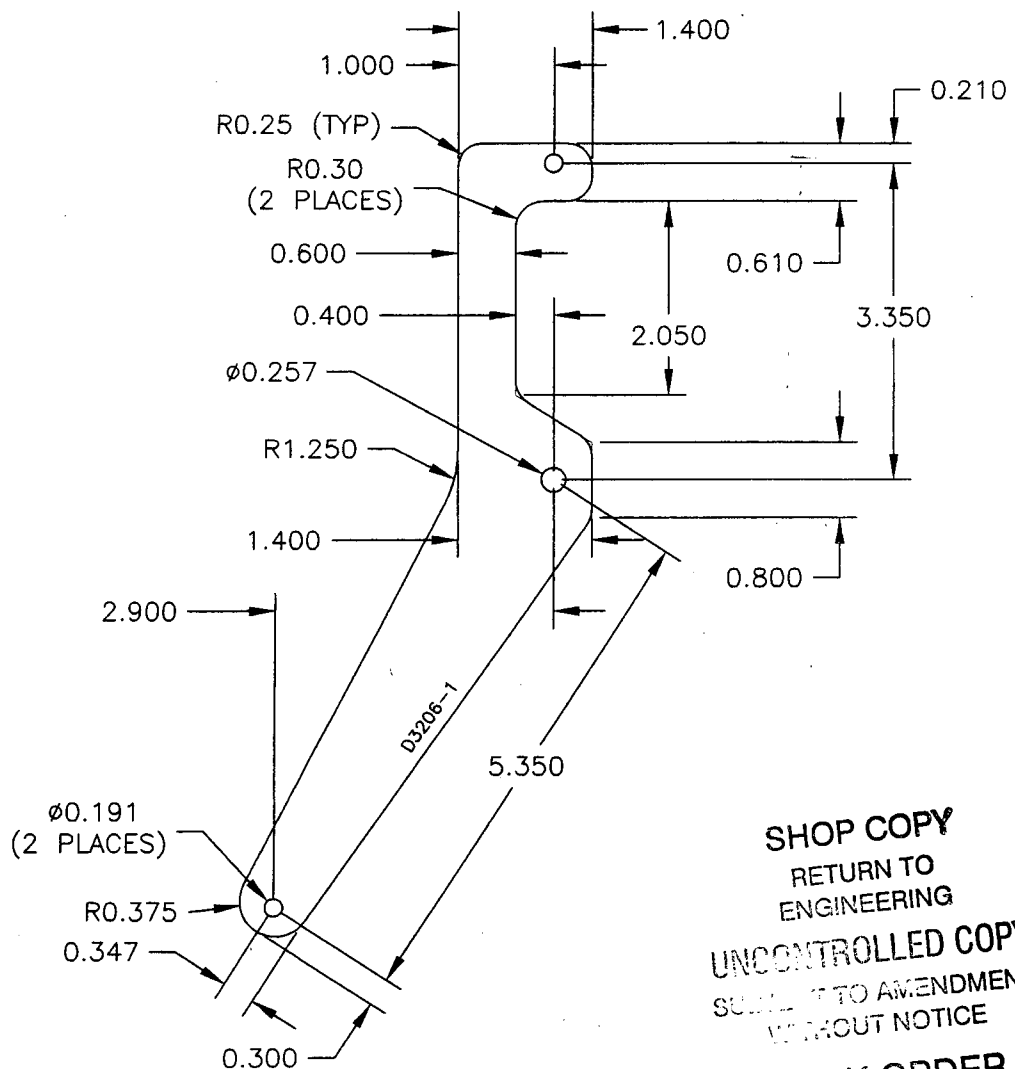
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3206	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE PEDAL ARM	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.01.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21786

NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNERS 0.005 TO 0.010
- 2) MATERIAL: AISI 4130N SHEET, 11 GAUGE (M4130N-S125)
- 3) FINISH POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 21, 2004
03:29 pm

Work Order No : 0021786
Project Name : D3206-1
Project For : WK449
Work Order Type : Main
Main WO Number :
House Part Number : D3206-1

Description : Pedal Arm
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 10-21-04
Est Finish Date : 11-30-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

BENEDICT-MILLER INC.

LYNDHURST NJ

REPORT OF CHEMICAL AND PHYSICAL TESTS

3/30/99

INDUSTRIAL LASER CUTTING
#7 - 7504 VANTAGE PLACE
DELTA BRITISH COL
CANADA V4G 1A5 00000-0000

P.O.#: 2303990-01
ORD#/LN#: 489101/12.00

.125" HR ALLOY 4130 AQ ANN SHEET PO 36" X 72"
2 PCS. 188 LBS. HEAT#: 2134252

Decarb=72/74 RA
AMS 2301G *J

AMS 6350H

CHEMICAL ANALYSIS

Carbon	(C)	.300
Manganese	(MN)	.440
Phosphorus	(P)	.008
Sulphur	(S)	.001
Silicon	(SI)	.220
Lead	(PB)	
Nickel	(NI)	.020
Chromium	(CR)	.830
Molybdenum	(MO)	.160
Copper	(CU)	.020
Vanadium	(V)	.005
Tungsten	(W)	
Tin	(SN)	.002
Cobalt	(CO)	
Aluminum	(AL)	.047

PHYSICAL PROPERTIES

Tensile	:	83990	PSI
Second Tensile	:	83990	PSI
Yield	:	56790	PSI
Second Yield	:	56790	PSI
Elongation	:	27	%-in 2 "
Second Elongation	:	27	%-in 2 "
%-Reduction-of-Area	:		%
Second %-Red-Of-Area	:		%
Bend-Test	:	OK	
Heat-Treat	:	35/34	
Hardness	:	82	RB
Macro	:	-	-
Decarb	:		
Grain-size	:	8	
Jominy-Hardenability	:	/ - / - /	
Frequency/Severity	:	.000 / .000	

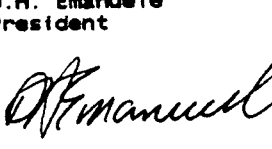
We hereby certify that the chemical and physical properties shown above are a true copy of original test reports furnished to us by the producing mill covering the heat or lot from which the material was furnished.

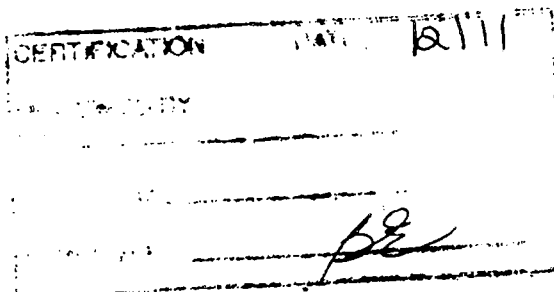
BENEDICT MILLER

By



BARBARA EBELING
CERTIFICATION SPECIALIST

8:51:20

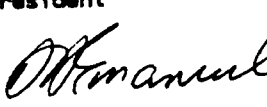
*** W C I S T E E L *** METALLURGICAL SERVICES INC. 1040 PINE AVE. SE WARREN, OHIO 44483-6528		033803																																																																																											
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Item	Specification and Description	03:00:43																																																																																											
1	HR SHEET ALLOY ULTIMET + SPEC AMS-8350 H AMS 2301 G ASTM-A-508-91 AISI-4130 FINE GRAIN AIRCRAFT STRL Q ANN P&O T/R LIGHT WT LIFT SPECIAL TEST .125N X 36.000 CE X 72 <table border="0" style="width: 100%;"> <tr> <td colspan="2">HEAT-NO</td> <td colspan="4">COIL NUMBERS</td> <td colspan="4"></td> </tr> <tr> <td>2134252</td> <td>H237501 1</td> <td>H237501 2</td> <td>H237501 3</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>H237501 4</td> <td>H237501 5</td> <td>I338101R 1</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>I338101R 2</td> <td>I338101R 3</td> <td>I338101R 4</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table> <table border="0" style="width: 100%;"> <tr> <td>HEAT-NO</td> <td>C</td> <td>MN</td> <td>P</td> <td>S</td> <td>SI</td> <td>CU</td> <td>NI</td> <td>CR</td> </tr> <tr> <td>2134252</td> <td>.30</td> <td>.44</td> <td>.008</td> <td>.001</td> <td>.22</td> <td>.02</td> <td>.02</td> <td>.83</td> </tr> <tr> <td></td> <td>MO</td> <td>SN</td> <td>AL</td> <td>V</td> <td>CB</td> <td>B</td> <td>TI</td> <td>ZR</td> </tr> <tr> <td></td> <td>.18</td> <td>.002</td> <td>.047</td> <td>.005</td> <td>.001</td> <td>.0002</td> <td>.003</td> <td></td> </tr> <tr> <td></td> <td>CA</td> <td>CE</td> <td>SB</td> <td>H</td> <td>N</td> <td>O</td> <td></td> <td></td> </tr> <tr> <td></td> <td>.0019</td> <td></td> <td>.000</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table> TI 01 C T/R FQA CERT TO INCLUDE ALL AQ TESTS REPORT TENSILE RESULTS FOR INFORMATION PURPOSES ONLY FAX NBR: 201 438 4982 ATTENTION OF: BARBARA EBELING CH C 28/33 MN 40/60 P 0250MX S 0100MX SI 15/35 NI 25MX CR 80/1.10 MO 15/25 AL RPT CU 35MX AK FINE GRAIN <p style="font-size: small;">WCI Steel Metallurgical Services Inc. is accredited by the American Association for Laboratory Accreditation in the fields of chemical and mechanical testing, certification # 0814-01 and 02 expiration 06/30/99.</p>	HEAT-NO		COIL NUMBERS								2134252	H237501 1	H237501 2	H237501 3							H237501 4	H237501 5	I338101R 1							I338101R 2	I338101R 3	I338101R 4						HEAT-NO	C	MN	P	S	SI	CU	NI	CR	2134252	.30	.44	.008	.001	.22	.02	.02	.83		MO	SN	AL	V	CB	B	TI	ZR		.18	.002	.047	.005	.001	.0002	.003			CA	CE	SB	H	N	O				.0019		.000						
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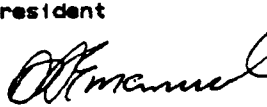
JUDITH A. REICHERT, NOTARY PUBLIC
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 MY COMMISSION EXPIRES 5/29/2003

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PAGE 2 of 8		
MELTED AND MANUFACTURED IN USA	PURCHASE ORDER: 08/07/98 5414	
CERTIFICATE OF TESTS	DATE/INVOICE: 12/02/98 899183759 WCI ORDER: 218 19 19789 01	
SOLD TO: BENEDICT-MILLER INC P O BOX 912 LYNDHURST NJ 07071	SHIP TO: BENEDICT-MILLER INC MARIN AVE & ORIENT WAY LYNDHURST NJ 07071	
I certify that the properties of the items tested are true and accurate. Material was sampled, tested and inspected in accordance with the methods prescribed in the governing specifications. Subject material also conforms to the requirements of the governing specifications. This report shall not be reproduced except in full.		D.H. Emanuele President 
Item	Specification and Description	03:00:43
HEAT NUMBER 2134252	RC 35 AFTER HEAT TREAT RC 34 AFTER HEAT TREAT FREQUENCY SEVERITY .000 .000 MCQUAID NORMALITY EHN TYPE II NORMAL 8.0	
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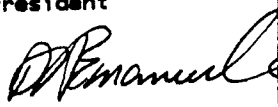
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	DECARB (INCHES) % .0001 00.0															
	RA 72 BEFORE GRIND, RA 74 AFTER GRIND															
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03:00:43		
Item	Specification and Description	
HEAT NUMBER 2134252	COIL NUMBER H237501 4	YIELD PSI 58790
		TENSILE PSI 83990
		ELONG 2" 27.4
		DIR T
DECARB (INCHES) % .0001 00.0		
RA 72 BEFORE GRIND, RA 74 AFTER GRIND		
	HARD- NESS RB82	BEND TEST OK
		DIR T
	YIELD PSI 58790	TENSILE PSI 83990
		ELONG 2" 27.4
		DIR T
DECARB (INCHES) % .0001 00.0		
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MELTED AND MANUFACTURED IN USA		PURCHASE ORDER: 08/07/98 5414
CERTIFICATE OF TESTS		DATE/INVOICE: 12/02/98 699183759 WCI ORDER: 218 19 19789 01
SOLD TO: BENEDICT-MILLER INC P O BOX 912 LYNDHURST NJ 07071		SHIP TO: BENEDICT-MILLER INC MARIN AVE & ORIENT WAY LYNDHURST NJ 07071
I certify that the properties of the items tested are true and accurate. Material was sampled, tested and inspected in accordance with the methods prescribed in the governing specifications. Subject material also conforms to the requirements of the governing specifications. This report shall not be reproduced except in full.		D.H. Emanuele President 
03:00:43		
Item	Specification and Description	
	HEAT COIL NUMBER NUMBER 2134252 H237501 5 RA 72 BEFORE GRIND, RA 74 AFTER GRIND HARD- BEND NESS TEST DIR RB82 OK T YIELD TENSILE ELONG PSI PSI 2" DIR 58330 82330 24.6 T I338101R 1 RA 74 BEFORE GRIND, RA 72 AFTER GRIND DECARB (INCHES) % .0001 00.0 HARD- BEND NESS TEST DIR RB84 OK T	
WCI Steel Metallurgical Services Inc. is accredited by the American Association for Laboratory Accreditation in the fields of chemical and mechanical testing, certification # 0814-01 and 02 expiration 08/30/99.		

JUDITH A. REICHERT, NOTARY PUBLIC
 STATE OF OHIO
 MY COMMISSION EXPIRES 5/29/2003

033803

MELTED AND MANUFACTURED IN USA

PURCHASE ORDER:
08/07/98 5414

CERTIFICATE OF TESTS

DATE/INVOICE: 12/02/98 899183759
WCI ORDER: 218 19 19789 01

SOLD TO:
BENEDICT-MILLER INC
P O BOX 912
LYNDHURST NJ 07071

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D.H. Emanuele
President

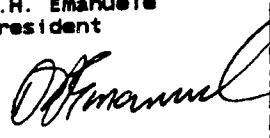
resident

Emanuel

03:00:43

Item	Specification and Description					
	HEAT NUMBER	COIL NUMBER	YIELD PSI	TENSILE PSI	ELONG 2"	DIR
	2134252	I338101R 2	58330	82330	24.6	T
	RA 74 BEFORE GRIND, RA 72 AFTER GRIND					
	DECARB (INCHES) % .0001 .00.0					
			HARD- NESS R884	BEND TEST OK	DIR T	
			YIELD PSI	TENSILE PSI	ELONG 2"	DIR
		I338101R 3	58330	82330	24.6	T
	RA 74 BEFORE GRIND, RA 72 AFTER GRIND					
<p>WCI Steel Metallurgical Services Inc. is accredited by the American Association for Laboratory Accreditation in the fields of chemical and mechanical testing, certification # 0814-01 and 02 expiration 06/30/99.</p>						

JUDITH A. REICHERT, NOTARY PUBLIC
STATE OF OHIO
MY COMMISSION EXPIRES 5/29/2003

*** W C I S T E E L *** METALLURGICAL SERVICES INC. 1040 PINE AVE. SE WARREN, OHIO 44483-8528		033803																																										
PAGE 8 of 8																																												
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